

Work Order ID 162738

162738

Page 1

Monday, June 12, 2017 10:52:23 AM

Item ID: SK145-0114-24

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hook

Start Date: 6/26/2017 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 5.00 *5*

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan:  Date: JUN 12 2017

Run Start *NR1*

QC: _____ Date: _____ Tooling: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
SK145-0114	N/R  17/06/22								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.21							
FLOW CNC Waterjet	1-Cut as per Dwg SK145-0114-24 flat Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.05							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.10							
Quality Control									

JUN 23 2017

Work Order ID 162738

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Item Name: Hook

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Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 5.00

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Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo use profile template	0.20 0.10			DAS 30 9-89				JUL 19 2017
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.10							DAS 38 9-89 JUL 18 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.05							

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Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.50

Quality Control

17/7/20



JUL 19 2017

Picklist Print

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Page 1

Work Order ID: 162738

162738

Parent Item: SK145-0114-24

SK145-0114-24

Parent Item Name: Hook

Start Date: 6/26/2017

Required Date: 7/3/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 17.06.06. NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S.125		Purchased		No		100	sf	2.0000	0.21	1.105263			

M1010S 125

1010-1025 sheet .125

**

re 17/06/22

Location

Loc Qty

Loc Code

MAT019

2

111741

2

137762

1.2

SK145-0114

[illegible]

Measured by:	de	Audited by:	DAS 38 9-89	Preliminary Approval:	
Date:	17/06/22	Date:	JUN 23 2017	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revE

D

C

B

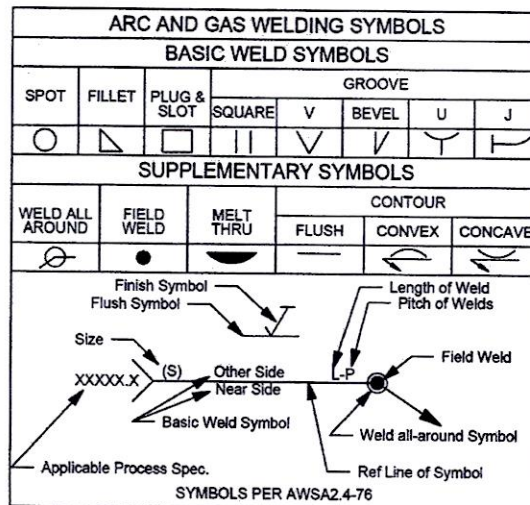
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NOTES:

1. INTERPRET DRAWING IAW ASME Y14.100
2. UNLESS OTHERWISE SPECIFIED, HOLES INDICATED WITH 3 PLACE PRECISION (ϕ .XXX) TOLERANCED IN ACCORDANCE WITH ASME B4.1-1987 CLASS LC 11 (HOLE H13).
3. CALCULATED FASTENER LENGTHS SHOWN. ACTUAL FASTENER LENGTHS TO BE DETERMINED AT INSTALLATION.
4. FUSION WELDING IN ACCORDANCE WITH AWS D1731 CLASS A UNLESS OTHERWISE SPECIFIED.
5. FUSION WELDING INSPECTION TO BE ACCOMPLISHED VISUALLY.
6. POWDER COAT NON ID SURFACES, EXCEPT SURFACE OF ITEM 02 TO WHICH ITEM 26 WILL BE BONDED, USING IFC COATINGS CUSTOM YELLOW P747 PT. OVERSPRAY ACCEPTABLE.
7. IDENTIFY MANUFACTURED PARTS PER MIL-STD-130 AS FOLLOWS: [CAGEC] [PN] [REV].
EXAMPLE: 81205 1234567890-501 A
8. SCUFF THE BOTTOM OF ITEM 26 AND THE TOP OF ITEM 02 PRIOR TO ADHERING THEM TOGETHER
9. BOND ITEM 26 TO ITEM 02 USING ONE OF THE FOLLOWING:
 - ITEM 45
 - CA40 (3M)
 - ITEM 46 WITH ITEM 47
 IF CA40 OR ITEM 46 WITH ITEM 47 ARE USED, PRIME SURFACE WITH ITEM 48 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162737
JUN 12 2017

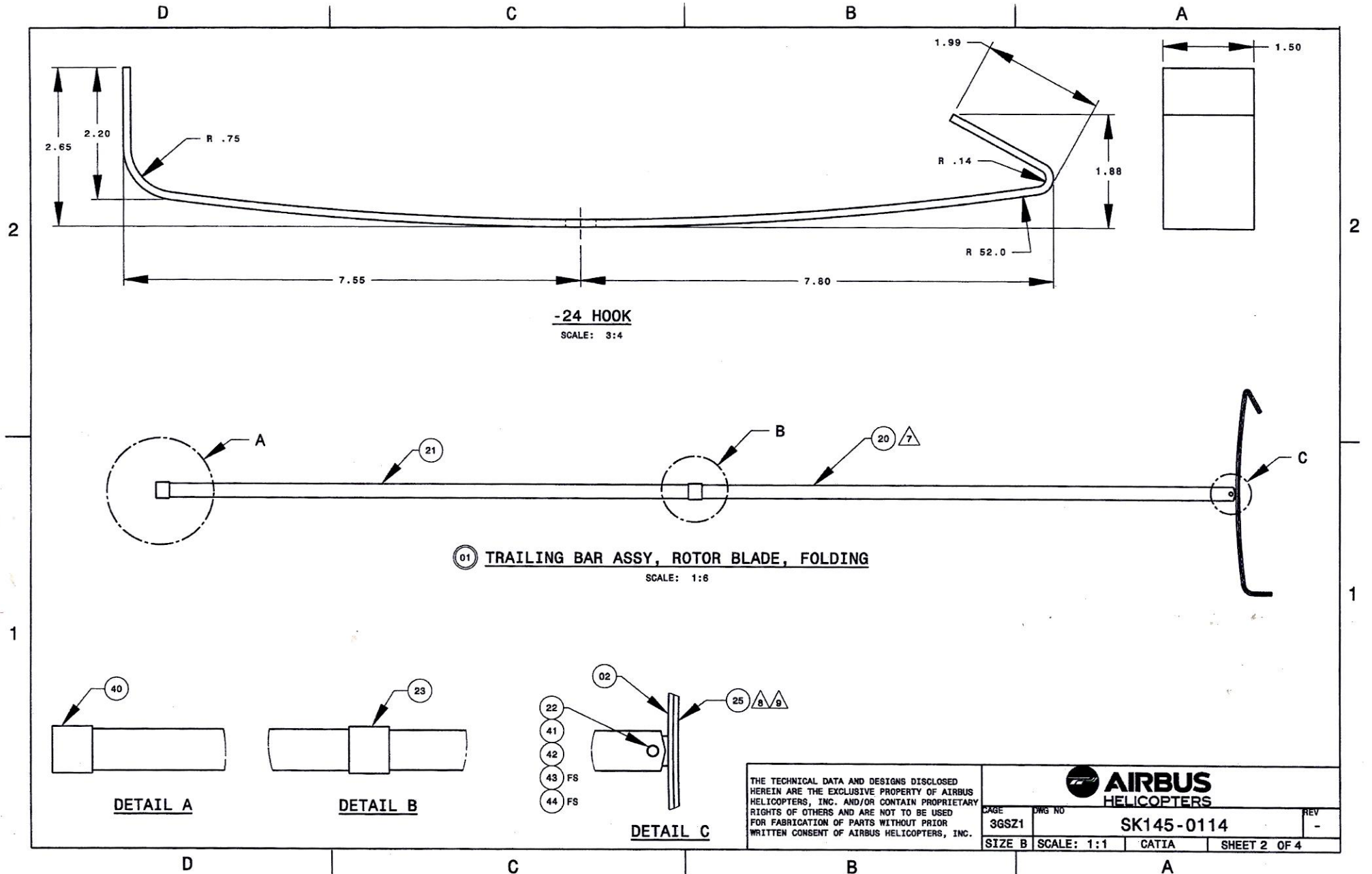
REVISION HISTORY			
SYM	DESCRIPTION	DATE	APPROVAL

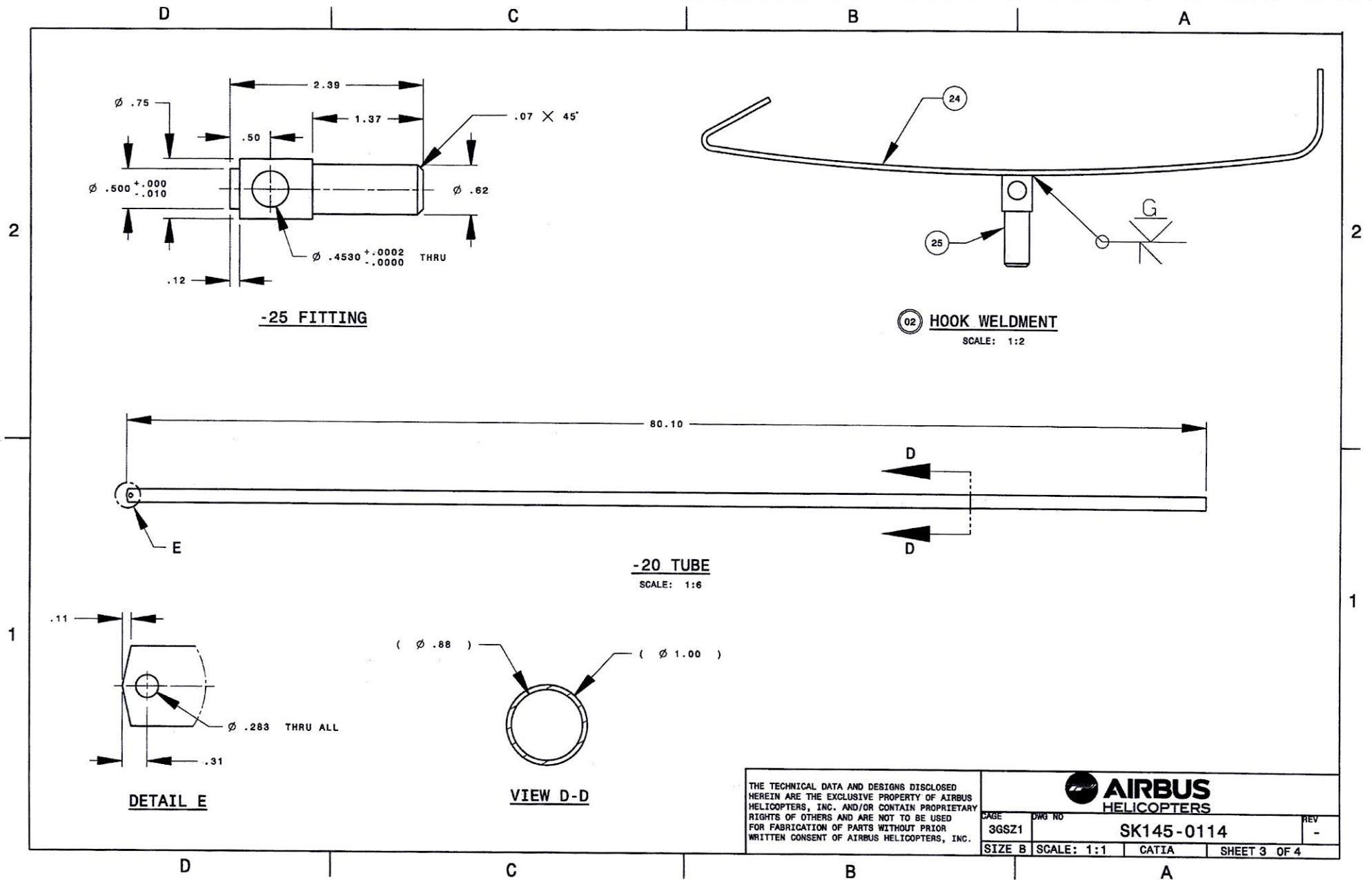


AR 48	PR200	METAL PRIMER	REMA		
AR 47	SC2000	CEMENT	REMA		
AR 46	UTR20	HARDENER	REMA		
AR 45	495	ADHESIVE	LOCTITE		
1 44	92198A111	BOLT	MTL SPEC		
1 43	NAS1149F0463P	WASHER	MTL SPEC		
1 42	MS35338-44	WASHER	MTL SPEC		
1 41	MS21042L4	BOLT	MTL SPEC		
1 40	84735K117	CAP	75A DIRMETER, BLACK		
1 26		-26 HOOK PAD	EPDM		
1 25		-25 FITTING	AISI 301 ANL AMS 5901		
1 24		-24 HOOK	HOT ROLLED STEEL SHEET	.125	
1 23		-23 COLLAR	84735K117 CAGEC 39428		
1 22		-22 BUSHING	AISI 301 ANL AMS 5901	ϕ .438	
1 21		-21 GRIP	BLACK VINYL VINYL	1.5	
1 20		-20 TUBE	2024-T3 AL ALY AMS-92-A-550/4	ϕ 1.000 X .080 WT	
05					
04					
03					
02		-02 HOOK WELDMENT			
01		-01 TRAILING BAR ASSY, ROTOR BLADE, FOLDING	661K1891-105A		
-05	-04	-03	-02	-01	ITEM NO.
QTY REQD		PART NUMBER	DESCRIPTION	MATL/SOURCE	STOCK SIZE NOTES

LIST OF MATERIALS

UNLESS OTHERWISE SPECIFIED, DIM ARE IN INCHES TOL ON ANGLES $\pm$.5° 1 PLACE $\pm$.1 2 PLACE $\pm$.03 3 PLACE $\pm$.010 INTERPRET DIM AND TOL PER ASME Y14.5-1994		DRAWING RELEASE ORDER 145-0981 NAME DATE 3/23/16 3/23/16 3/23/16 2/3/15		 AIRBUS HELICOPTERS TITLE TRAILING BAR ASSY, ROTOR BLADE, FOLDING CAGE 3GSZ1 DWG NO SK145-0114 REV - SIZE B SCALE: NONE CATIA SHEET 1 OF 4	
THE TECHNICAL DATA AND DESIGNS DISCLOSED HEREIN ARE THE EXCLUSIVE PROPERTY OF AIRBUS HELICOPTERS, INC. AND/OR CONTAIN PROPRIETARY RIGHTS OF OTHERS AND ARE NOT TO BE USED FOR FABRICATION OF PARTS WITHOUT PRIOR WRITTEN CONSENT OF AIRBUS HELICOPTERS, INC.		ENGR MGR PROJ ENGR ENGR CK DRAFT CK DRAWN BY J. Lo Piccolo NEXT ASSEMBLY			



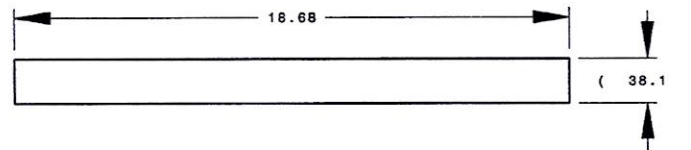
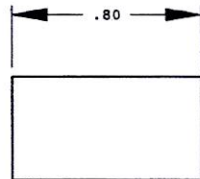


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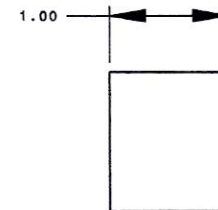
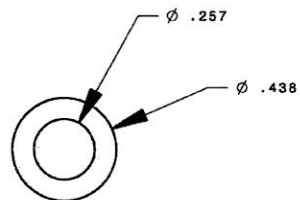
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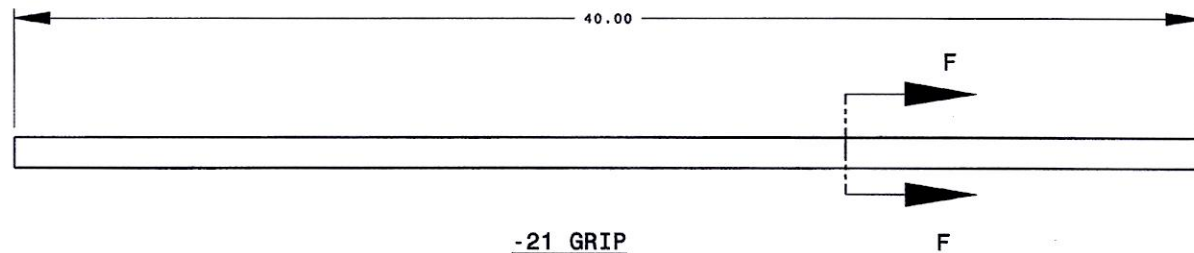
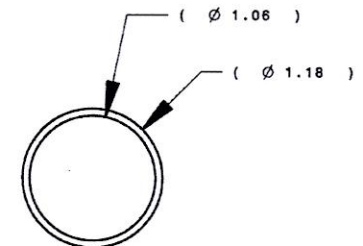
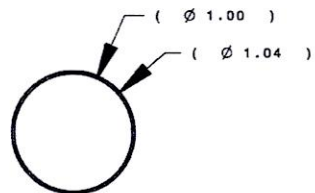
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-26 HOOK PAD-22 BUSHING

SCALE: 2:1

-23 COLLAR

SCALE: 1:1

-21 GRIPVIEW F-F

SCALE: 1:1

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FOR FABRICATION OF PARTS WITHOUT PRIOR
WRITTEN CONSENT OF AIRBUS HELICOPTERS, INC.

CAGE	DWG NO	REV
3GSZ1	SK145-0114	-
SIZE B	SCALE: 1:4	CATIA
SHEET 4 OF 4		

D

C

B

A